

Work Order ID 60392

July 7, 2010 11:44:18 AM



Page 1

Item ID: D044-715-011

Accept



Setup Start



Revision ID:

Item Name: R44 Cargo Mirror

Stop



Start Date: 7/07/10 Start Qty: 5.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
----------	--------------

D3243	Rev A
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IIN-D044-715	Rev A
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100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

220



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

CHG003

8/10/08/04

8/10/08/03

10/8/03 (5)

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Stop



Start Date: 7/07/10 Start Qty: 5.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

230



QC

Quality Control

Operation
Description

QC4- 100% Inspect kits for completeness

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

8/10/08/04



240



Packaging

Packaging

Packaging

0.00

0.00

10/8/08 SF (5)

Memo
Identify and pack for shipping as per PPP D044-715-011

42
N-5

250



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/08 HJ

MF
10-08-05

Picklist Print

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Work Order ID: 60392



Parent Item: D044-715-011



Parent Item Name: R44 Cargo Mirror

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 104.02.18 (New issue: KJ/JLM)

IPP Rev:B 06-04-28 Manufactured on Water Jet JLM

IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3243-041



Bracket Assembly

Manufactured

No

Each

10.0000

5



*ENSURE inserts
are installed!*

Location

ST226

Loc Qty

10

Loc Code

*38776 10
56249 40*

D1048



Saddle

Manufactured

No

230

Each

34.0000

10



Location

ST002

Loc Qty

34

Loc Code

*56283 90
59236 10*

D1049



Saddle

Manufactured

No

230

Each

19.0000

10



Location

ST002

Loc Qty

19

Loc Code

58 396

6/18/10

Picklist Print

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Work Order ID: 60392



Parent Item: D044-715-011



Parent Item Name: R44 Cargo Mirror

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 5.00

Required Qty: 5.00

D2010-104



Mirror Arm 369/500

Manufactured

No

230

Each

26.0000

1 5



Location

Loc Qty

Loc Code

ST220

26

55735

55735

6

56840

20

D2011-101



6" Mirror

Manufactured

No

230

Each

25.0000

1 5



1486151

AN3-4A



Bolt

Purchased

No

230

Each

1,335.000

4 20



58388

Location

Loc Qty

Loc Code

ST350

1335

104214

206

1114214

104291

300

104322

200

104374

200

104625

300

104817

129

Picklist Print

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Work Order ID: 60392



Parent Item: D044-715-011



Parent Item Name: R44 Cargo Mirror

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 5.00

Required Qty: 5.00

AN526C1032R10

Purchased

No

230

Each

458.0000

4

20



h

S
Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST327	100	
114494	100	
ST328	358	
108062	126	
110049	232	

ALS4-1032-130

Purchased

No

230

Each

4,762.000

4

20



R

I
Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
PKG11	4446	
114723	4446	
ST282	277	
110511	38	
114407	239	
ST381	39	
114654	39	

AN960JD10L

NAS1149D0332J

Purchased

No

230

Each

3,275.000

4

20



E 19/83 (6)

S
Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST348	3275	
110985	3275	

110985

32.2 CARGO MIRROR REMOVAL

- 32.2.1 Remove the AN3 bolts securing the D3243-041 Bracket to the skidtube and remove the Cargo Mirror.
- 32.2.2 Reinstall the AN3-4A bolts in the inserts. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-715-011 Cargo Mirror Installation	1.3 lb 0.59 kg	41.7 in 1.06 m	54.2 lb-kg 0.63 m-kg	32.0 in 0.81 m	41.6 in-lb 0.48 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D044-715-011	CARGO MIRROR INSTALLATION
2	D1048	Clamp
2	D1049	Saddle
1	D2010-104	Arm
1	D2011-101	Mirror
1	*D3014-1	Locknut
1	D3243-041	Bracket
4	ALS7-1032-130	Insert (or AKS7-1032-130; AKS4-1032-130, ALS4-1032-130)
4	AN3-4A	Bolt
4	AN526C1032R10	Screw (or AN526-1032R10)
4	AN960JD10L	Washers
1	*AN960JD416L	Washer

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

TC Accepted

MAR 31 2004

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